

**Work Order ID 76797****\*76797\***

Page 1

Monday, November 21, 2011 11:10:51 AM

Item ID: D2662-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Saddle, RH In 206  
Start Date: 11/21/2011 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan:      Date: 11-11-24 Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D2662	Rev E								

100

0.00

**\*100\***

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

**Memo**

Program part number and batch number.  
Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB069 &amp; DWG

DWG REV: EFOLIO REV: BA

B.A 11/10/08

8

φ

110

0.00

**\*110\***

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

**Memo**

Machine Keyway and inspect per attached dimension sheet

B.A 11/10/08

8

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Q

W/O:		WORK ORDER CHANGES					
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**\*76797\***

Monday, November 21, 2011 11:10:51 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 11/21/2011    **Start Qty:** 8.00    **\*8\***

**Required Date:** 1/10/2012      **Req'd Qty:** 8.00      **\*Q\***

Run Start \*NR1\*

Stop \*NR2\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

## Powder Coating

## Memo

START TIME:

FINISH TIME: \_\_\_\_\_

OVEN TEMPERATURE:

0.00

0.00

160

### QC3- Inspect Part Finish

0.00

**\*160\***

QC

## Quality Control

## Memo

170

Identify as per dwg & Stock Location: 935 0.00

**\*170\***

### Packaging

## Packaging

## Memo

0.00

W/O:		WORK ORDER CHANGES					
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Required Date: 1/10/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

11/12/14 [Signature]

11-12-14 (8)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Monday, November 21, 2011 11:10:55 AM

Page 1

Work Order ID: 76797

**\*76797\***

Parent Item: D2662-2

**\*D2662-2\***

Parent Item Name: Saddle, RH In 206

Start Date: 11/21/2011

Required Date: 1/10/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC IPP REV:D  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	152.0000	1	8			
<b>*D6101-001*</b>									<b>**</b>				
Saddle Billet													

11-12-07

Location	Loc Qty	Loc Code
MAT040	152	
66965	1	
69677	2	
73774	60	
74648	21	
74679	68	

8


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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	76797
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2662-2
<b>Inspection Dwg:</b> D2662 Rev. D 		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.120	.120	.120	.121		
B	0.100	0.140		.132	.131	.132	.132		
C	1.125	1.145		1.139	1.138	1.136	1.136		
D	0.615	0.685		.685	.685	.685	.685		
E	0.240	0.260		.246	.247	.248	.248		
F	1.313	1.343		1.324	1.324	1.324	1.324		
G	0.210	0.230		.218	.218	.219	.219		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.579	1.578	1.576	1.576		
K	0.235	0.240		.237	.237	.237	0.238		
L	0.100	0.120		.112	.112	.112	0.112		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.512	.512	.512	0.512		
O	5.990	6.010		6.000	5.999	5.999	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.313	.313	.313	0.314		
S	0.315	0.322		.316	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.793	.797	.798	.797		
W	0.550	0.560		.550	.548	.549	.550		
X	1.679	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.257	.257	.257	.257		
Z	0.912	0.932		.923	.920	.919	.920		
AA	0.490	0.510		.503	.499	.498	0.499		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	11-12-07

Audited by:	cmf
Date:	11/12/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	76797
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2662-2
<b>Inspection Dwg:</b> D2662 Rev. <del>D</del> E		Page 1 of 1

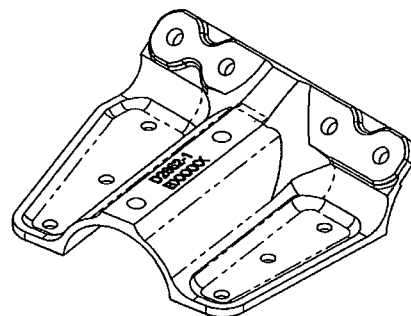
Inspect dimensions highlighted on inspection sheet drawing D2662 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.100	0.140		0.121	0.124	0.124	0.124		
B	0.100	0.140		0.132	0.130	0.131	0.130		
C	1.125	1.145		1.136	1.136	1.137	1.136		
D	0.615	0.685		0.685	0.685	0.685	0.685		
E	0.240	0.260		0.248	0.250	0.250	0.250		
F	1.313	1.343		1.324	1.324	1.324	1.324		
G	0.210	0.230		0.219	0.220	0.220	0.220		
H	0.100	0.180		0.140	0.140	0.140	0.140		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.576	1.576	1.576		
K	0.235	0.240		0.238	0.238	0.238	0.238		
L	0.100	0.120		0.112	0.112	0.112	0.112		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
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U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.798	0.798	0.798		
W	0.540	0.560		0.549	0.549	0.549	0.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.257	0.260	0.257	0.257		
Z	0.912	0.932		0.920	0.920	0.920	0.920		
AA	0.490	0.510		0.499	0.498	0.498	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

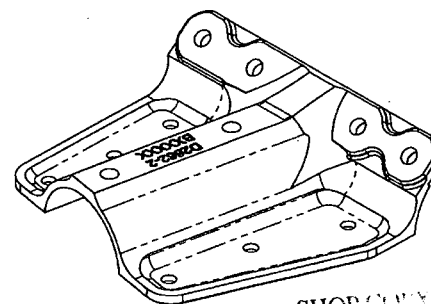
Measured by:	SL	B.A
Date:	11-12-07	11/12/08

Audited by:	cmf
Date:	11/12/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	



**D2662-1 SADDLE, INSIDE, LH**



**D2662-2 SADDLE, INSIDE, RH**

SHOP COPY

REVISION

UNCONTROLLED COPY

WITH NO. 76-798

WORK

NO. 76-798

**RELEASED**  
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP' DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

**DART AEROSPACE USA, INC.**

KENT, WA

DRAWING NO.

**D2662**

REV. E

SHEET 1 OF 5

TITLE

**SADDLE, INSIDE**

SCALE

NTS

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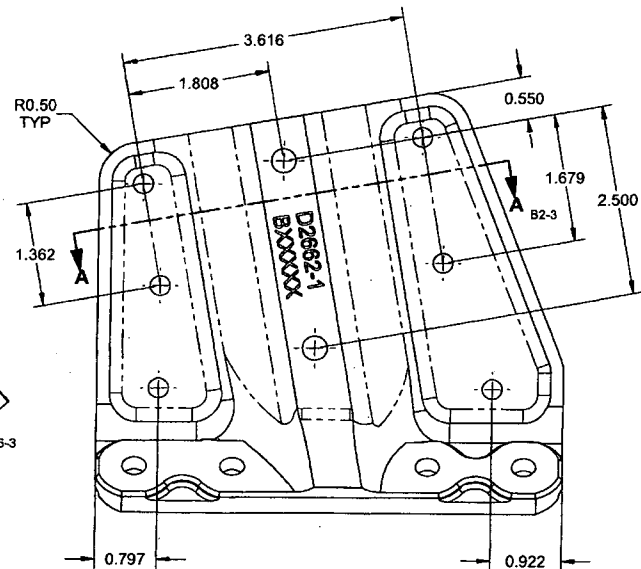
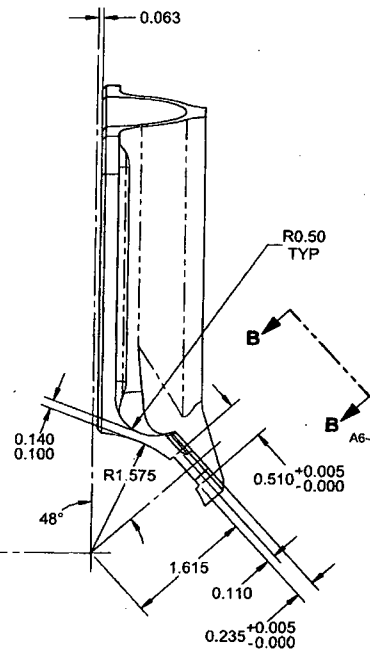
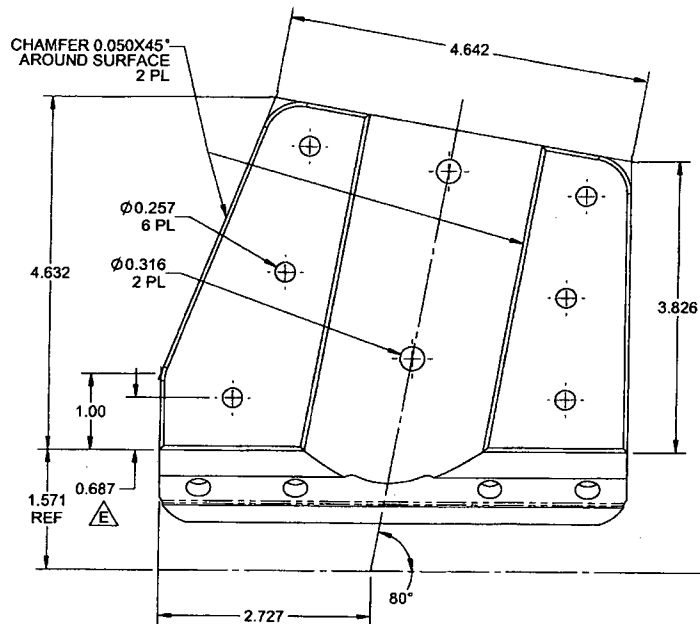
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**NOTE:** Date & initial all entries



# **D2662-1 SADDLE, INSIDE, LH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	90	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	90	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	WLB	D2662	SHEET 2 OF 5
APPROVED	WLB	TITLE	SCALE
DE APPR.	WLB	SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED  
2011-11-16



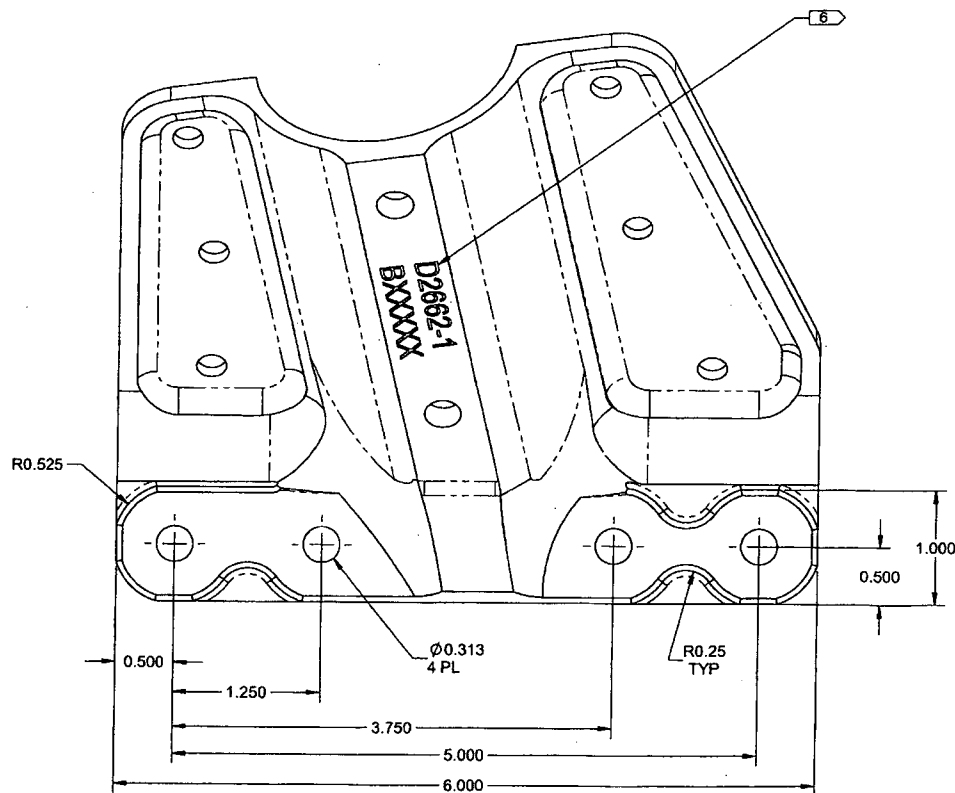
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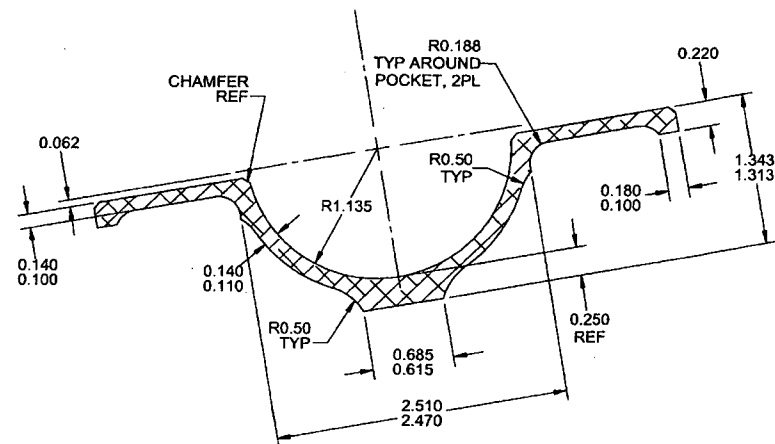
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**VIEW B-B**  
SCALE 1.5X B4-2  
VIEW ROTATED



**VIEW A-A** C1-2  
SCALE 1.5X

**RELEASED**  
2011-11-16

76797

DESIGN	92	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	92	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		<b>D2662</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>SADDLE, INSIDE</b>	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

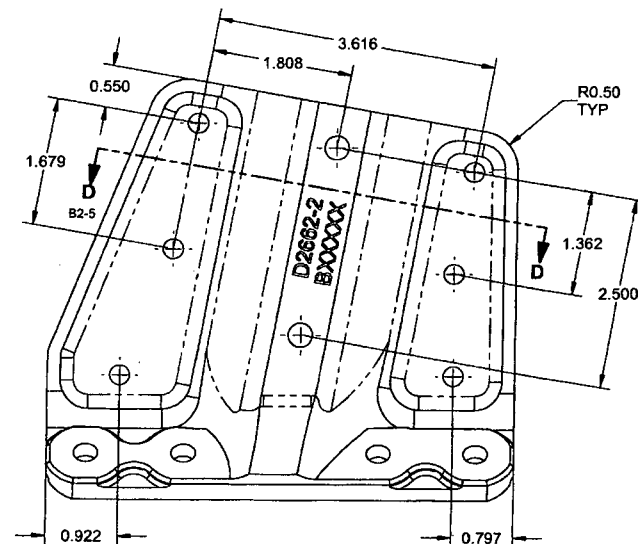
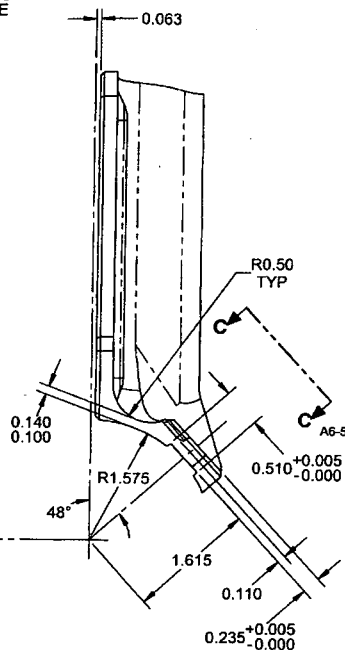
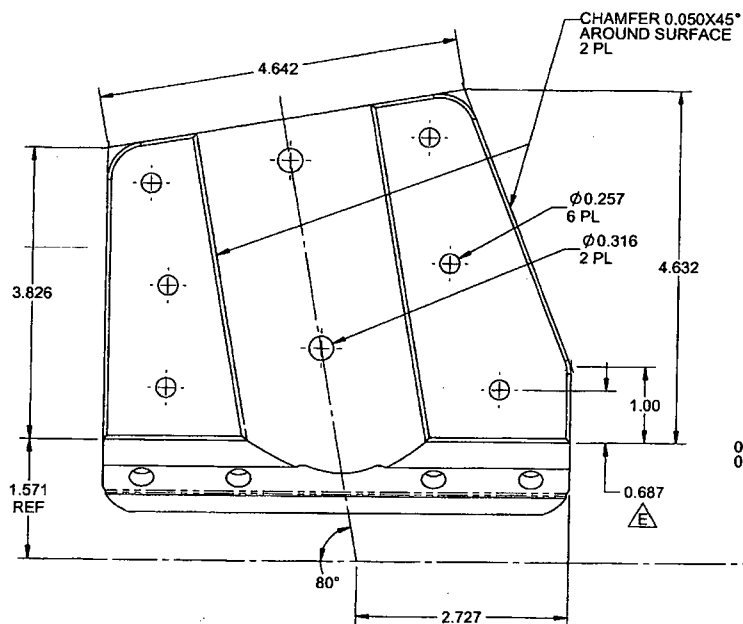
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2011-11-16

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN	88	DART AEROSPACE USA, INC.	
DRAWN	88	KENT, WA	
CHECKED	88	DRAWING NO.	REV. E
MFG. APPR.	88	D2662	SHEET 4 OF 5
APPROVED	88	TITLE	SCALE
DE APPR.	88	SADDLE, INSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC.	
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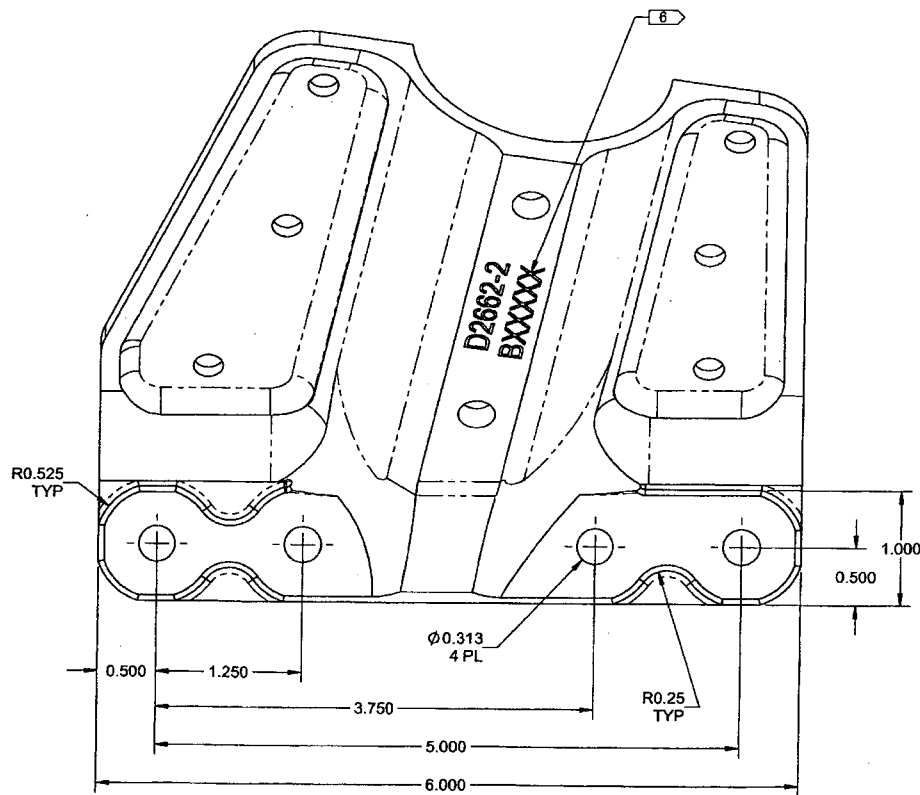
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

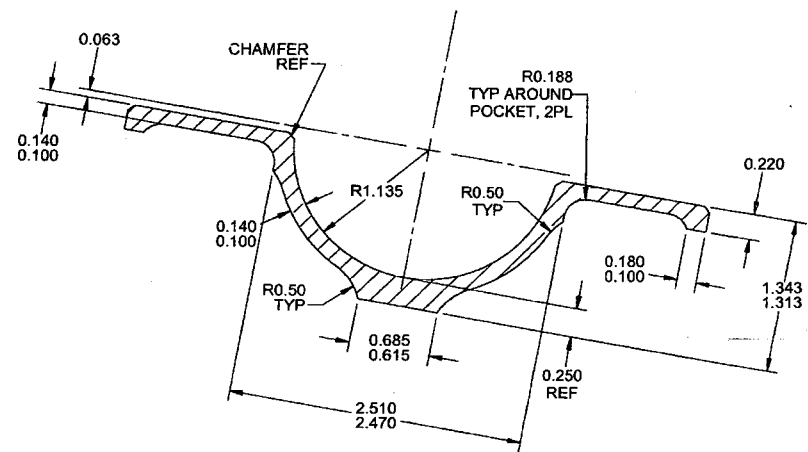
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**VIEW D-D** B4-4  
SCALE 1.5X  
VIEW ROTATED



**VIEW C-C** C3-4  
SCALE 1.5X

**RELEASED**  
2011-11-16

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. <b>D2662</b>	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		<b>SADDLE, INSIDE</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries